

January-20-12 10:30:14 AM

# U/R

Page 1

Stop **\*NR2\***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79118

**\*79118\***

Page 2

January-20-12 10:30:14 AM

Item ID: D2940-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: U/R Stop **\*NS2\***  
 Item Name: Support  
 Start Date: 20/01/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 02/03/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:




Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.								
140		0.00							
<b>*140*</b>									
QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							
170		0.00							
<b>*170*</b>									
Packaging	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
Packaging	Memo	0.00							

AS 12-2-14 (20)

(180) PTO

AS 12-2-15 (20)

W/O: 79118 Perm. Chang.		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/02/15	# 140	Change step to ac 5		2012.17		 12/02/17	 12/02/15

Part No: D2940-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 79118****\*79118\***

Page 3

January-20-12 10:30:14 AM

Item ID: D2940-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID: U/R

Stop **\*NS2\***

Item Name: Support

Start Date: 20/01/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 02/03/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

*[Signature]* M.L.J 12/02/16

*12-02-16*  
*(20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-20-12 10:30:17 AM

Page 1

Work Order ID: 79118

**\*79118\***

Parent Item: D2940-1

**\*D2940-1\***

Parent Item Name: Support

Start Date: 20/01/2012

Required Date: 02/03/2012

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP C 02.11.26Reformat; Added P/OKJ

IPP Rev:D Added priming as per Rev B 07-04-30 JLM

IPP E 08.03.19 Re-format Ec verified by DD

IPP Rev:F 08-10-22 add qc14 DD verified by:EC

IPP Rev:G

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	14.0000	0.5	10.52632			

**\*DSK081\***

D2940-1 TURNING DETAIL

**\*\***

## Location

## Loc Qty

## Loc Code

MAT060

14

69717

4

→ 77304

10

10

on 12/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	79118
<b>Description: Ø3.250 Support</b>		<b>Part Number:</b>	D2940-1
<b>Inspection Dwg: D2940</b>	<b>Rev:</b> <i>12/01-20</i>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.150	.150	.150	.150	.150
AD	3.510	3.530		3.510	3.510	3.520	3.520	3.520
AE	1.633	1.673		1.650	1.650	1.652	1.655	1.657
AF	1.493	1.513		1.502	1.505	1.499	1.502	1.504
AG	0.040	0.060		.053	.056	.049	.049	.049
AH	0.188	0.193		.192	.192	.192	.192	.192
AI	0.140	0.160		.147	.145	.145	.146	.149
AJ	2.518	2.538		2.528	2.525	2.528	2.528	2.528
AK	0.040	0.060		.048	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.147	.144	.144	.144	.144
AN	0.350	0.450		.380	.375	.375	.375	.375
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.150	.150	.152	.153	.153
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: *am* Date: 12/02/05

Audited by: *b.a* Date: 12/02/11

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 79118
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b> D2940-1
<b>Inspection Dwg:</b> D2940	<b>Rev:</b> 2	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.150	.150	.150	.150	.150
AD	3.510	3.530		3.520	3.520	3.520	3.517	3.518
AE	1.633	1.673		1.653	1.655	1.654	1.656	1.658
AF	1.493	1.513		1.503	1.503	1.501	1.502	1.505
AG	0.040	0.060		.050	.049	.050	.051	.049
AH	0.188	0.193		.192	.192	.192	.192	.192
AI	0.140	0.160		.146	.149	.147	.147	.147
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.144	.144	.144	.145	.144
AN	0.350	0.450		.375	.375	.375	.375	.370
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.150	.152	.153	.153	.153
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: *amr* Date: 12/02/06

Audited by: *b.a* Date: 12/02/11

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 79118
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b> D2940-1
<b>Inspection Dwg:</b> D2940	<b>Rev:</b> 12/01-20	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.150	.150	.150	.150	.155
AD	3.510	3.530		3.522	3.522	3.522	3.522	3.525
AE	1.633	1.673		1.660	1.654	1.658	1.658	1.653
AF	1.493	1.513		1.506	1.506	1.507	1.506	1.500
AG	0.040	0.060		.049	.049	.047	.046	.047
AH	0.188	0.193		.188	.188	.188	.188	.191
AI	0.140	0.160		.148	.147	.145	.147	.148
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.150	.150	.150	.150	.150
AN	0.350	0.450		.375	.375	.375	.375	.375
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.154	.155	.156	.155	.160
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.130	4.130	4.129
AV								
AW								
Accept/Reject								

Measured by: JH Date: 12-02-09

Audited by: B.A Date: 12/02/11

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	79118
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: <i>B</i>	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

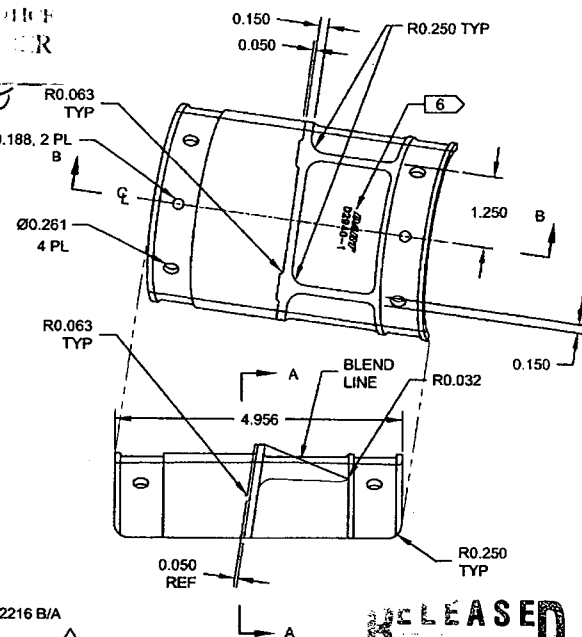
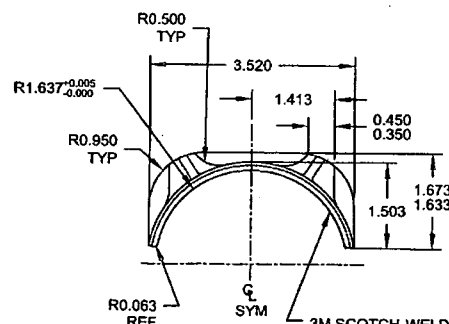
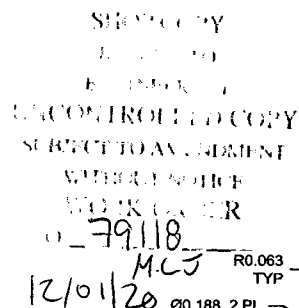
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
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AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.155	.155	.155	.155	.155
AD	3.510	3.530		3.522	3.525	3.522	3.523	3.522
AE	1.633	1.673		1.655	1.656	1.655	1.661	1.657
AF	1.493	1.513		1.504	1.507	1.507	1.510	1.507
AG	0.040	0.060		.050	.054	.052	.049	.051
AH	0.188	0.193		.191	.191	.191	.191	.191
AI	0.140	0.160		.149	.150	.149	.146	.150
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.150	.150	.150	.150	.150
AN	0.350	0.450		.375	.375	.375	.375	.375
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.152	.150	.150	.153	.151
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.129	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: *JL* Date: *12-02-09*

Audited by: *H.A* Date: *12/02/11*

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>[Signature]</i>



RELEASED  
2011-07-28

**NOTES:**

- |   |  |  |              |
|---|--|--|--------------|
| C   | RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION | CP                                     | 11.07.15     |
| B   | UPDATE PER NCR 642, PRIME INSIDE               | PH                                     | 07.03.13     |
| A   | NEW ISSUE                                      | CP                                     | 01.01.10     |
| REV.  | DESCRIPTION                                    | BY                                     | DATE         |
| DESIGN  | <i>q</i>                                       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN   | <i>q</i>                                       | HAWKESSBURY, ONTARIO, CANADA           |              |
| CHECKED   | <i>ASS</i>                                     | DRAWING NO.                            | REV. C       |
| MFG. APPR.  | <i>[Signature]</i>                             | D2940                                  | SHEET 1 OF 1 |
| APPROVED  | <i>[Signature]</i>                             | TITLE                                  | SCALE        |
| DE APPR.  | <i>[Signature]</i>                             | Ø3.250 SUPPORT                         | NTS          |
| DATE  | 11.07.15                                       | COPYRIGHT © 2001 BY DART AEROSPACE LTD |              |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. |  |  |              |

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries